












Date: Tuesday, 2/28/2006 9:27:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 25959	
Estimate Number : 11041	
P.O. Number : N/A	Part Number : D2809
This Issue : 2/28/2006 S.O. No. : N/A	Drawing Number : D2809 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/27/2006 Type : MACHINED PARTS	Drawing Revision : A1
Previous Run :	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/10/2006
Checked & Approved By : <u>06.02.28</u>	Qty: <u>60</u> Um: <u>25</u> Each
Comment : Est C 02.03.07 Now turned in house NG	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M6061T6R0500 6061-T6 Round Bar .500"
	 
Comment: Qty.: 0.1045 f(s)/Unit Total : 2.6119 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: <u>M 19296</u>	
2.0	HARDINGE HARDINGE CNC LATHE SMALL
	 
Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204 <u>MS 06/03/15 60</u>	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>MS 06/03/15 60</u>	
4.0	QC8 SECOND CHECK
	 
Comment: SECOND CHECK <u>MS 06/03/15 60</u>	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr all sharp edges as per dwg <u>MS 06/03/15 60</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 26/03/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/28/2006 9:26:36 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 25959

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MA 06 03 16

(60)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat _____ per QSI 005 4.3

DC 06/03/17

(60)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 388

SB

06/03/20

60

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/21

(60)

Job Completion



U 060321

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

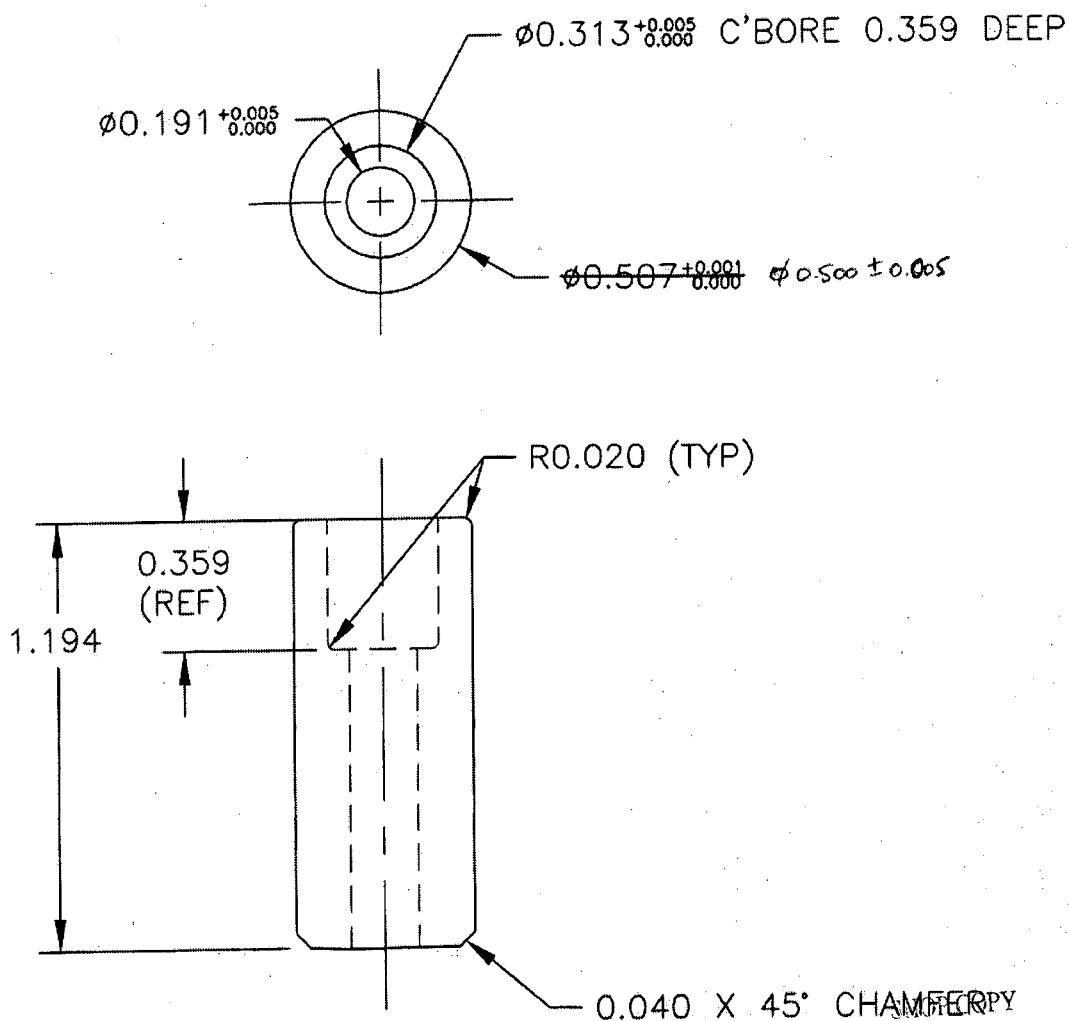
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ W/ $\phi 0.507$	

RELEASED
00.11.13



NCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
L: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25959

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4.3
PER DART QSI 005